

Date: Wednesday, 12/7/2005 8:26:30 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 25148
Estimate Number : 10940
P.O. Number : N/A Part Number : D29381
This Issue : 12/7/2005 S.O. No. : N/A Drawing Number : D2938 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
Previous Run : N/A Material : N/A
Due Date : 1/20/2006 Qty: 8 Um: Each
Written By : SEE COMMENT BELOW
Checked & Approved By : SEE ABOVE USER & DATE
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length

(D6101-003)

Batch No: BZ-1844

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number. - BL

1-Inspect part number and batch number are programmed correctly. EP 06/01/17

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet BL

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet EP 06/01/18

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr EP 06/01/18

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet SD 06.04.13

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET EP 06/01/18 SD 06.04.13

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK TRK 06/04/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 06/04/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 8:26:31 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 25148

Part Number: D29381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

g.m

06-04-18

8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

g.m

06-04-18

8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AP 6/4/19 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5T476*

AP 06/04/19 (8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AP 06/04/20 (8)

Job Completion



u 06/04/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 25118
Description: 206 Saddle, Outboard, Left side		Part Number: D2938-1
Inspection Dwg: D2938 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.125	0.126	0.123	0.122		
B	0.100	0.140		0.126	0.124	0.123	0.124		
C	0.100	0.140		0.120	0.115	0.115	0.117		
D	0.210	0.230		0.218	0.216	0.216	0.216		
E	1.245	1.255		1.248	1.249	1.247	1.246		
F	1.245	1.255		1.248	1.249	1.247	1.246		
G	2.495	2.505		2.498	2.497	2.499	2.497		
H	0.510	0.515		.515	.515	.515	.515		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.499	2.501	2.501		
K	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		0.123	0.123	0.123	0.122		
O	0.540	0.560		0.543	0.547	0.547	0.545		
P	0.490	0.510		0.497	0.497	0.497	0.497		
Q	3.715	3.725		3.718	3.717	3.718	3.718		
R	2.720	2.760		2.724	2.742	2.747	2.747		
S	0.240	0.270		0.248	0.247	0.247	0.248		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.367		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.250	1.270		1.258	1.259	1.259	1.257		
Y	1.565	1.585		1.565	1.574	1.574	1.573		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>EP</i> / <i>SD</i>	Audited by: <i>gm</i>
Date: 06/01/17 06.04.13	Date: 06/04/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	

DART AEROSPACE LTD	Work Order:	2548
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.122	0.127	0.124	0.122		
B	0.100	0.140		0.122	0.125	0.123	0.122		
C	0.100	0.140		0.118	0.118	0.118	0.118		
D	0.210	0.230		0.216	0.217	0.216	0.217		
E	1.245	1.255		1.247	1.245	1.247	1.246		
F	1.245	1.255		1.247	1.245	1.247	1.246		
G	2.495	2.505		2.499	2.498	2.499	2.497		
H	0.510	0.515		.515	.515	.515	.515		
I	1.572	1.582		1.576	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.500	2.500	2.500		
K	0.257	0.262	DT8683	0.259	0.259	0.259	0.257		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		0.123	0.123	0.123	0.123		
O	0.540	0.560		0.544	0.545	0.544	0.544		
P	0.490	0.510		0.501	0.497	0.500	0.497		
Q	3.715	3.725		3.720	3.715	3.716	3.718		
R	2.720	2.760		2.747	2.747	2.747	2.747		
S	0.240	0.270		0.249	0.247	0.247	0.246		
T	0.100	0.180		0.146	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.365	1.367	1.366	1.367		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.250	1.270		1.259	1.260	1.259	1.259		
Y	1.565	1.585		1.567	1.574	1.574	1.573		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EP / SA
Date:	06/01/18 06.03.13

Audited by:	JM
Date:	06/04/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	